

# Work Order ID 84316

**\*84316\***

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May-09-12 1:45:37 PM

Item ID: D3393-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Battery Lock Assembly  
 Start Date: 09/05/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 23/05/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/09 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3393	Rev A								
100		0.00							
<b>*100*</b>	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest. 2-Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-53-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten								
110		0.00							
<b>*110*</b>	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Tack Weld lock shaft to flat cam of a Max 1/8" Long Qty Part Number Description Batch A/RN/A SS Rod <u>M114509</u>								
120		0.00							
<b>*120*</b>	QC9- Inspect visual per QSI004- Fusion Welds								
QC	Memo	0.00							
Quality Control									

2

PF 12-06-20

2

PD 12-08-03

3x

CP 12-8-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

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**\*84316\***

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**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Item Name:** Battery Lock Assembly

**Start Date:** 09/05/2012      **Start Qty:** 4.00

**\*4\***

**Cust Item ID:**

**Required Date:** 23/05/2012      **Req'd Qty:** 4.00

**\*4\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

### Operation Description

## Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

## Memo

0,00

## Quality Control

12/8/89

MF  
12.08.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

May-09-12 1:45:40 PM

Page 1

Work Order ID: 84316

\*84316\*

Parent Item: D3393-041

\*D3393-041\*

Parent Item Name: Battery Lock Assembly

Start Date: 09/05/2012

Required Date: 23/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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5/16WC		Purchased	No			100	Each	1,766.000	2	8			
<b>*5/16WC*</b>									**			(2)	FF 12-06-20
SS Flat Washer 5/16 FW516S1													

Location	Loc Qty	Loc Code
ST377 115072	1746	
120262	1746	
ST522	20	
120208	20	

9567K21		Purchased	No			100	Each	91.0000	2	8			
<b>*9567K21*</b>									**			(2)	FF 12-06-20
Polyethelene Cap													

Location	Loc Qty	Loc Code
ST380 120743	91	
120743	91	

D2728-7		Manufactured	No			100	Each	0.0000	0	0			
<b>*D2728-7*</b>									**			(2)	FF 12-06-20
Dart Logo label													

D3373-1		Manufactured	No			100	Each	43.0000	1	4			
<b>*D3373-1*</b>									**			(2)	FF 12-06-20
Cam Lock													

Location	Loc Qty	Loc Code
ST039 44105	43	
58463	2	
74862	19	
75666	22	

W/O:		WORK ORDER CHANGES					
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# Picklist Print

May-09-12 1:45:40 PM

Page 2

Work Order ID: 84316

**\*84316\***

Parent Item: D3393-041

**\*D3393-041\***

Parent Item Name: Battery Lock Assembly

Start Date: 09/05/2012

Required Date: 23/05/2012

Start Qty: 4.00

Required Qty: 4.00

D3393-1

Manufactured No

100

Each

11.0000

1

4

**\*D3393-1\***

Battery Lock Casing

\*\*

(2) FF 12-06-20

Location

Loc Qty

Loc Code

st493

11

79171

11

D3393-3

Manufactured No

140

Each

0.0000

1

4

**\*D3393-3\***

Cam Lock Shaft

\*\*

2

FF 12-06-20

77090

May-09-12 1:45:40 PM

Shop Packet Print

Page 2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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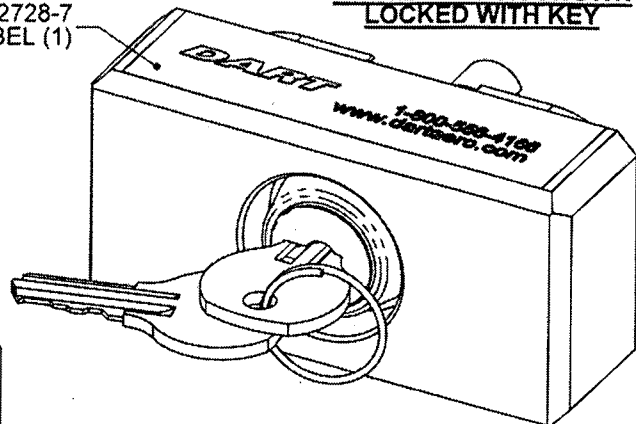
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED  
*[Signature]*

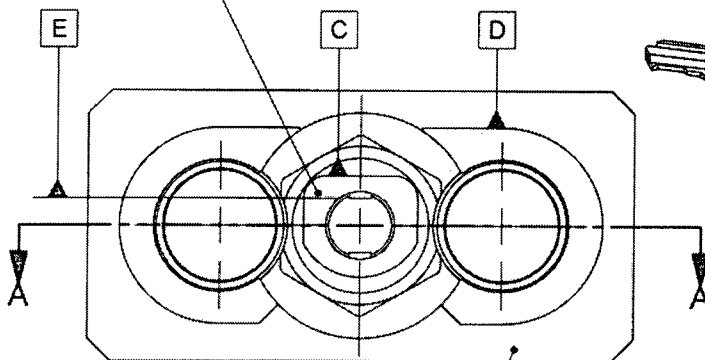
05/03/09

D2728-7  
LABEL (1)

**BATTERY LOCK SHOWN  
LOCKED WITH KEY**



POSITION FACE **C** OF D3369-5  
PARALLEL TO FACES **D** AND **E**  
AS SHOWN



D3373-1  
CAM LOCK  
ASSEMBLY (1)

D3393-1  
CASING (1)

Ø5/16" WC S/S  
WASHER (2)

D3369-5 SPACER (1)

PRESS FIT POLYETHYLENE CAP (2)   
AND APPLY KRAZY GLUE

D3393-3 CAM  
LOCK SHAFT (1)

0.09<sup>+0.03</sup>  
-0.01 (2 PLACES)

TACK WELD  
D3393-3 TO D3369-5

**SECTION A-A**

### **D3393-041 BATTERY LOCK ASSEMBLY**

#### **NOTES:**

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMaster-CARR, P/N 9567K21

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 84310 MJS  
12/05/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

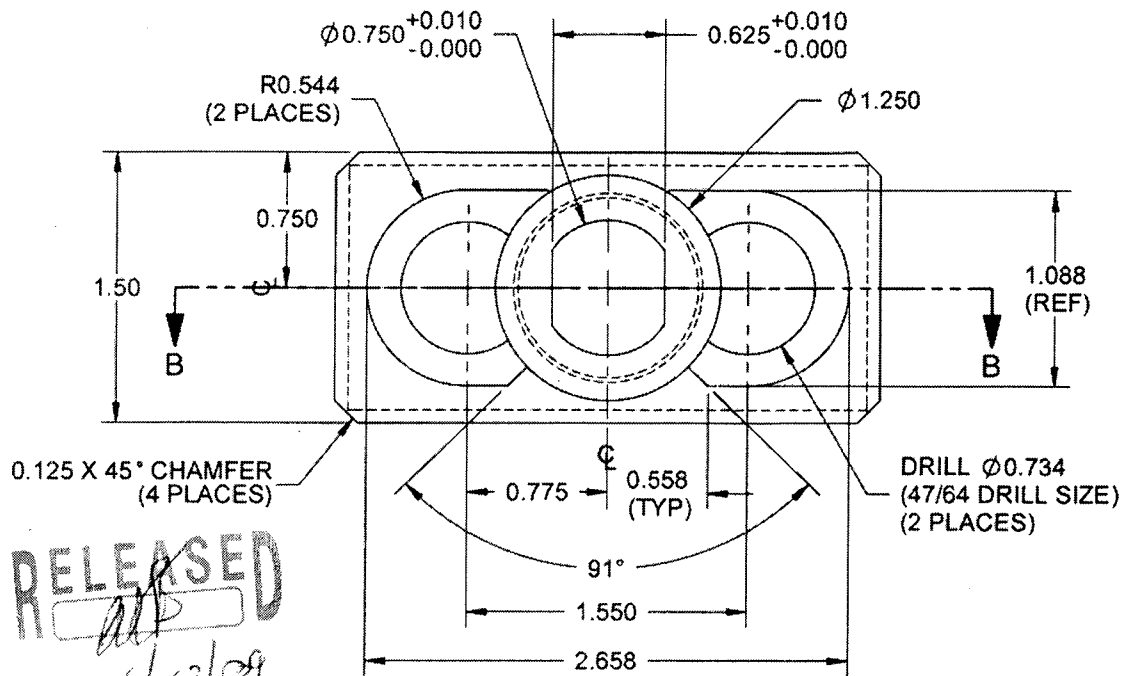
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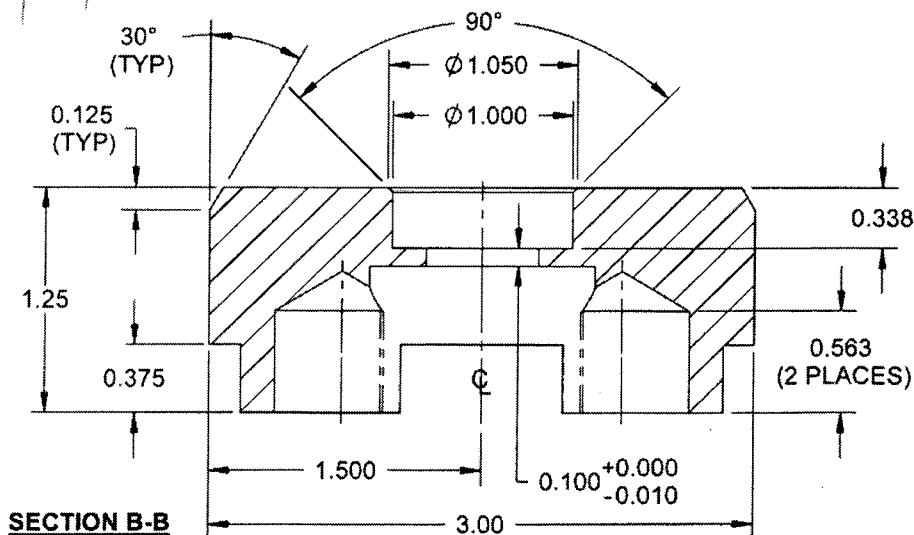
NOTE: Date & initial all entries



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CHECKED <i>TF</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3393</b>	REV. A SHEET 2 OF 3
DATE <b>05.02.09</b>	TITLE <b>BATTERY LOCK</b> SCALE 1:1		



RELEASED  
*[Signature]*  
05/03/09



**SECTION B-B**

**D3393-1 CASING**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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84314

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

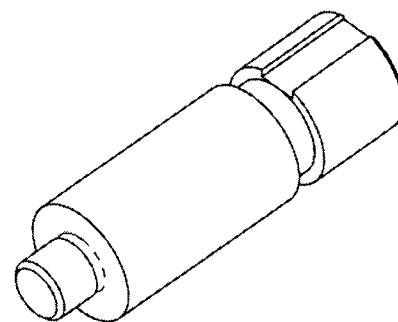
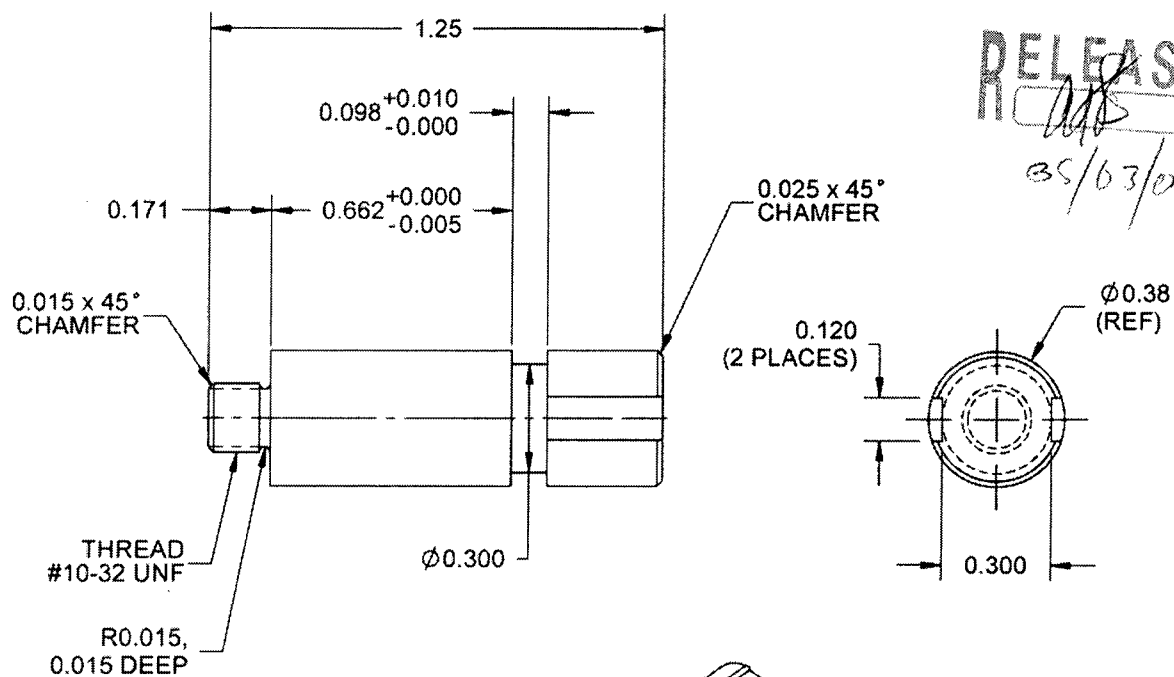
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**NOTE:** Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3393</b>	REV. A SHEET 3 OF 3
DATE <b>05.02.09</b>		TITLE <b>BATTERY LOCK</b>	SCALE 2:1



### D3393-3 CAM LOCK SHAFT

#### NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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04316

W/O:		WORK ORDER CHANGES					
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